

Work Order ID 57558

April 8, 2010 10:04:43 AM



Page 1

Item ID: D3773-3

Accept



Setup Start



Revision ID:

Item Name: Leg

Stop



Start Date: 4/08/10 Start Qty: 4.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 4.00



Customer:

Reference: *PL 10-04-08*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D3773	Rev B	

100



DOOSAN LATHE

Doosan

Memo

0.00

*PL 10/04/12**4 0*

Doosan Lathe

1- Turn as per Folio FA763 Rev: A & Dwg D3773 Rev: B 2-Deburr
per dwg D3773

110



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

*PL 10/04/12**4 0*

Quality Control

120



QC8- Inspect parts - second check

QC

Memo

0.00

*MW= 10/04/12**4 0*

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: 249

0.00

10/04/13 G

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/14 J

Quality Control

*ME
10-4-14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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April 8, 2010 10:04:42 AM

Work Order ID: 57558



Parent Item: D3773-3



Parent Item Name: Leg

Start Date: 4/08/10

Required Date: 4/16/10

Comments: IPP Rev:A New Issue 08-07-18 DD Verified By:ec

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR1.000W.065		Purchased		No		110	f	24.5830	4.2105			

304 RD Tube 1.00 x .065W



Warehouse

Location

Main Warehouse

MAT

24.583

108922

10

110010

14.583

4.2105 on R 10/04/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	S7558
Description: Leg	Part Number:	D3773-3
Inspection Dwg: D3773	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>Onf</u>	Audited by:	<u>MW</u>	Prototype Approval:	N/A
Date:	<u>10/04/12</u>	Date:	<u>10/04/12</u>	Date:	N/A
Rev	Date	Change	Revised by	Approved	
A	08.09.04	New Issue	KJ/DD	<u>Onf</u>	<u>Onf</u>



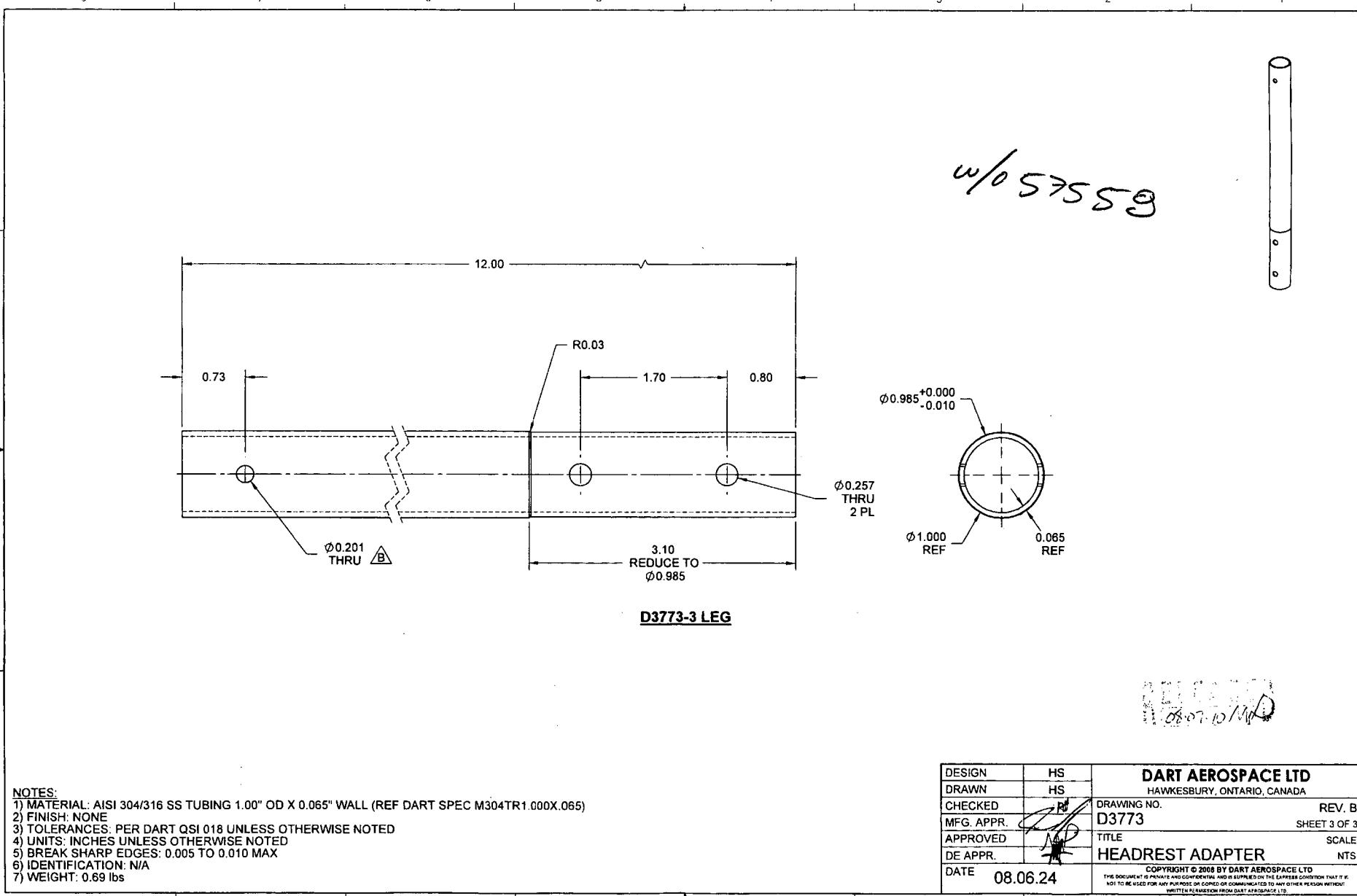
What is Waste

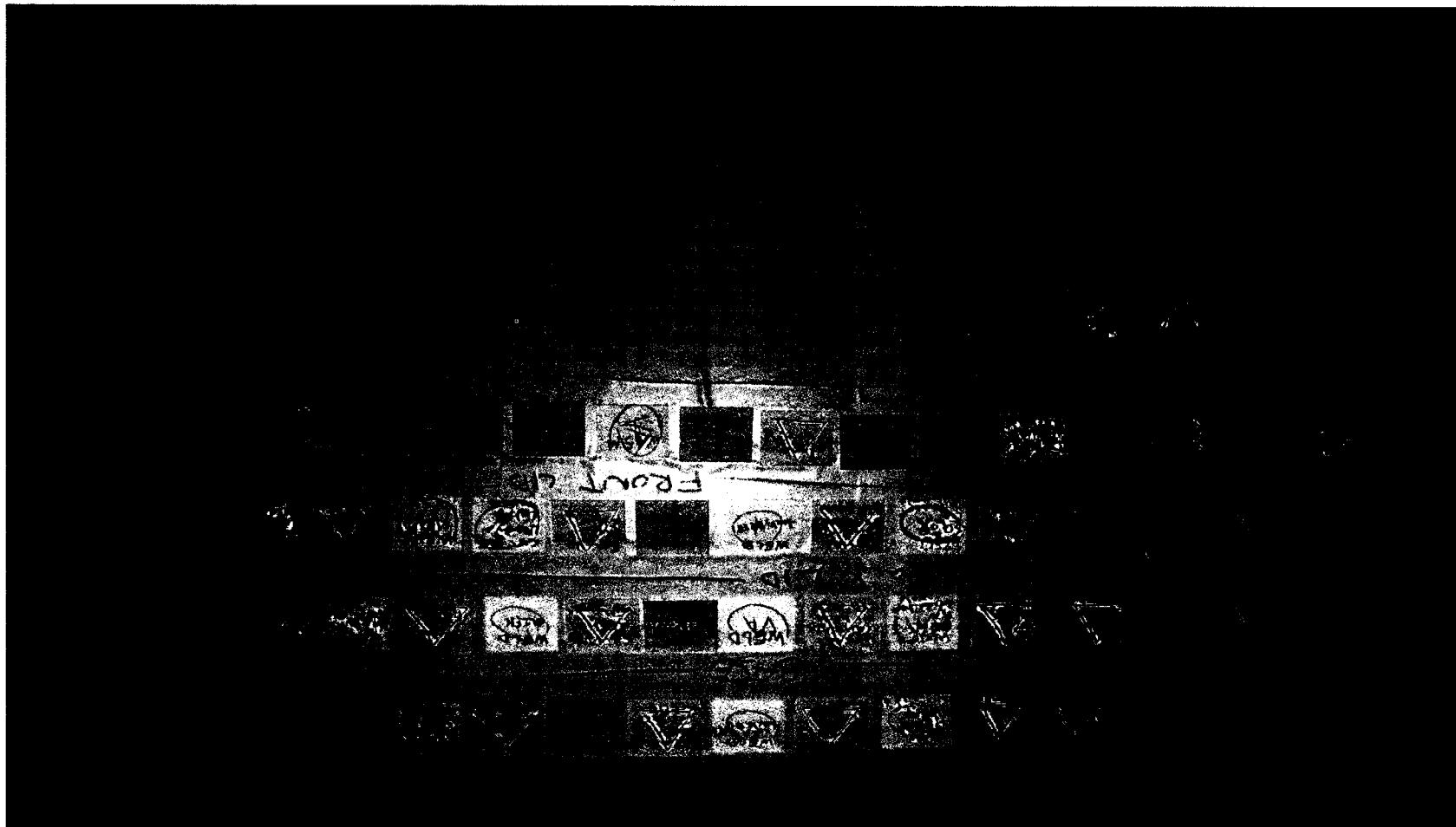
An activity or output that ***adds cost but does not add value*** as perceived by the end-use customer.

Elimination of waste - activities that utilize resources but do not create value must be eliminated. This is an ongoing hunt! Ideally it will involve all employees.

If you could explain to your customer what ***every step of*** your operation cost, are there any steps your customer would not be willing to pay for?

- scrap
- rework
- looking for: parts, tools, material, people, etc.
- rescheduling
- expedited shipments
- ??????????





Value stream mapping during Kaizen
event.